

NCL-19-7388



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G04132-3G-5

Job Sheet 198051



Deviation

Part No: RBW6405G04132-3G-5

Job Qty: 4 pcs

Part Name: Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/22/19

Job Tracking No:

Due Date: 9/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6405G04132-3G Rev.E IPP Rev. A 19.03.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	NV5000 - 1	4 pcs	9/20/19	9/20/19	1.00	8.00	NV5000 - 1		
120	QC 8	4 pcs	9/20/19	9/20/19	0.00	0.00	NV5000 - 2		ALA.
							QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
125	Outsource - 4 - Anodize	4 pcs	9/20/19	9/20/19			GR0002-VC		
126	Packaging 2-1 - Receive - B4B	4 pcs	9/20/19	9/20/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		

19-08-28

LA 19-08-30

2019-09-03



Container No: S209640



Part: RBW6405G04132-3G-5

Job No: 198051

Serial No/Batch: S209640

Revision: E

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/28/19

Plex 7/22/19 8:10 AM Dart.lajeunesse.marie

				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	OP SEP 09 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
127	QC 6	4 pcs	9/20/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
130	Packaging 3-1 - Stock - B4B	4 pcs	9/20/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
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					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
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					Packaging 3 - 21 - B4B

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
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				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	4 pcs	9/20/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - 1-Machine as per folio FC <u>453</u> FOLIO REV: <u>AA</u> DWG REV: <u>E</u> 2-Debur Descriptions: 120 - QC8- Inspect parts - second check 125 - -Issue P/O; <u>44411</u> -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant - Material type; 6061T6 -Certificate of Conformity is required 126 - (Receive & Inspect for Damage & Mat'l Certs) C of C required. 127 - QC6- All purchased or subcontracted products 130 - Identify as per dwg & Stock Location: _____ 140 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B3.000X5.000	6061T6 Bar 3.000 X 5.000	3.5520 ft (.888 ea)	100-NV5000 - 1	<u>S089 917</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-NV5000 - 1	M6061T6B3.000X5.000	4	5	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 198051
Description: Frame		Part Number: RBW6405604132-36-S
Inspection Dwg: RBW6405604132-36 Rev: E		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.516	$\pm .008$ $- .001$	.515	✓		G-P	—
1.496	$\pm .005$	1.496	✓		VERN.	MGP-04
3.149	$\pm .005$	3.153	✓		VERN.	MGP-04
4.331	$\pm .005$	4.330	✓		"	"
2.048	$\pm .005$	2.048	✓		"	"
R.205	$\pm .005$	R.204	✓		GP	—
R.332	$\pm .005$	R.330	✓		GP	—
R.41	$\pm .010$	R.409	✓		G-P	—
.465	$\pm .005$	.465	✓		VERN.	MGP-04
Ø.375	$\pm .006$ $- .001$	.375	✓		G-P	—
8.346	$\pm .005$	8.349	✓		VERN.	CNC-02
.788	$\pm .005$	.786	✓		VERN.	MGP-04
2.165	$\pm .005$	2.164	✓		VERN.	MGP-04
1.417	$\pm .005$	1.416	✓		"	"
3.94	$\pm .010$	3.94	✓		"	"
10.551	$\pm .005$	10.549	✓		VERN.	CNC-02
2.560	$\pm .005$	2.559	✓		VERN.	MGP-04
.064	$\pm .005$	.064	✓		"	"
30.4°	$\pm 1°$	30°	✓		A-G	—
.461	$\pm .005$	.464	✓		VERN.	MGP-04
0.02 x 45°	$\pm .005$	.022 x 45°	✓		VERN.	MGP-04
.778	$\pm .005$	.810	✓		"	"
1.426	$\pm .005$	1.425	✓		"	"
.2188	$\pm .005$	.216	✓		VERN.	MGP-04
1.1242	± 8.8888 $- 8.8888$	1.1245	✓		MIC.	MGP-02
Ø.157	± 8.8888 $- 8.8888$	.157	✓		G-P	—
.295	$\pm .005$	.292	✓		VERN.	MGP-04
45°	$\pm 1°$	45°	✓		A-G	—

Measured by: ALA/	Checked by: D.	QC Inspector:
Date: 19-08-27	Date: 19-08-30	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

**Special Comments:**

2019-09-09

Plex 9/9/19 1:50 PM Dart.Guerin.Kimberley



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044411



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	197054	649.5213	Doubler Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF- 23377 TYPE 1 CLASS N	Firmed	-	9/11/19	36 pcs	0 pcs	36 pcs	\$6.45/pcs	\$232.20
4	197004	646.9910	Struts Issue P/O to ATG: Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C	Firmed	-	9/11/19	15 pcs	0 pcs	15 pcs	\$13.40/pcs	\$201.00
	198145			Firmed	-	9/11/19	20 pcs	0 pcs	20 pcs	\$13.40/pcs	\$268.00
Sub Total:							35	0	35		\$469.00

5	198051	RBW6405G04132-3G-5	Frame Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE- 2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	9/11/19	5 pcs	0 pcs	5 pcs	\$4.55/pcs	\$22.75
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SEP 09 2019

\$ 209 640

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OP



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044411



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	198949	RBW6005G01631-3G-2	Bottom Clamp -Issue P/O; -ANODIZE COLOR RED, PER IAW -MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed -		9/11/19	4 pcs	0 pcs	4 pcs	\$4.55/pcs	\$18.20

24

SEP 09 2019

S 210 402

DP

Grand Total: \$954.79

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/9/19 1:50 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918559

Date: 09-Sep-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
5 ea	Part: RBEM632V4001102-5 Indicator Plunger Anodize per MIL-A-8625F, Type II, Class1, Clear, Water Sealant.0004-.0010" (.4 - 1 mils) Job: 25885 PO: POHB044411		Rev: 1 Line: 1
19 ea	Part: RBW6500G03531-3G-4 Flange Support Anodize per MIL-A-8625F, Type II, Class2, Black, Water Sealant .0004-.0010" (.4 - 1 mils). Job: 25886 PO: POHB044411		Rev: A Line: 2
5 ea	Part: RBW6405G04132-3G-5 Frame Anodize per MIL-A-8625F, Type II, Class2, Red, Water Sealant .0004-.0010" (.4 - 1 mils). Job: 25889 PO: POHB044411		Rev: E Line: 5
4 ea	Part: RBW6005G01631-3G-2 Bottom Clamp Anodize per MIL-A-8625F, Type II, Class2, Red, Water Sealant .0004-.0010" (.4 - 1 mils). Job: 25890 PO: POHB044411		Rev: A Line: 6
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>SEP 09 2019</u> Made in Canada.		

DAS
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9-89



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918559

Date: 09-Sep-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. RECEIVED SEP 09 2019 DART AEROSPACE LTD.	
Made in Canada.		

Entered: 7k Date: Oct 31/9

Date:



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7588

Route update only

Job: 198051		DISPOSITION		DEPARTMENT/PROCESS							
Part No. RBWG405G04132-3G-5 REV E		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☒ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: 2019-08-28		Sequence #: 100		QTY Affected: 5				MRB (QSI042) WPD 14-08-28			
Description Work Order Deviation				Disposition				Completed By ALA-19-08-28			
DIMENSION 0.778 ACCEPTABLE TO BE ~ 0.820				THIS DEVIATION IS ACCEPTABLE TO USE AS IS FIT, FORM AND FUNCTION WILL BE AS ORIGINALLY INTENDED				Lead hand / Supervisor D-n 19-08-30			
Root Cause				FAULT CATEGORY							
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up		☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
Other/Details:											